

Work Order ID 82886-2

82886

Page 1

April-10-12 2:38:46 PM

Item ID: D4406-043

Revision ID:

Item Name: Alt Wearplate Assembly

Start Date: 10/04/2012 Start Qty: 8.00

Required Date: 24/04/2012 Req'd Qty: 8.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: Process Plan: *MLJ*

Date: 12/04/10 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4406

B

0.00

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per dwg D4406-3

prog rev: *1*

dwg rev: *1*

2-Deburr if required

0.00

110

QC 2- Inspect parts off machine FAIL/FAIL

0.00

110

QC

Quality Control

Memo

12-4-13

(9)

12-4-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82886

April-10-12 2:38:46 PM

82886

Page 3

Item ID: D4406-043

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Alt Wearplate Assembly

Start Date: 10/04/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

150

0.00

150

Large Fab

Memo

0.00

Large Fab

Weld bar as per dwg

A/R 2059b harcoat Batch# M122030

Weld bar to wearplate as per dwg

A/R s.s. rod Batch# M120023

160

160

QC

Quality Control

QC 10- Inspect visual per QSI004- ground welds

0.00

QC9

Memo

0.00

QC5

170

0.00

170

Small Fab

Memo

0.00

Small Fab

Apply coating as per dwg D4406

①

EL 12-6-13

①

Ppl 12-06-13

1

M120614

1 &

②

12/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 82886

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82886

Page 4

Item ID: D4406-043

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Alt Wearplate Assembly

Start Date: 10/04/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location: _____

0.00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

1 of 12 10-6-15.

12/6/15

12/6/18

ME 12-06-15

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April-10-12 2:38:49 PM

Page 1

Work Order ID: 82886

82886

Parent Item: D4406-043

D4406-043

Parent Item Name: All Wearplate Assembly

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 8,00

Required Qty: 8,00

Comments: IPP Rev A 11.06.06new issue EC verified by:DD
12.02.06 as per dwg revPBI DD verified

IPP rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA

Purchased

No

100

sf

169,7860

2,92

24,58947

**

M304S18GA

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

158,786

119032

2,3

119383

33,486

119766

3

120604

120

MAT20

11

121192

11

D4407-3

Manufactured

No

150

Each

12,0000

2

16

**

D4407-3

Bar

Location

Loc Qty

Loc Code

ENG

-10

WA

22

80759

8

80796

4

83308 x 2

R 12-6-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	02886
Description: Plate		Part Number:	D4406-3
Inspection Dwg: D4406 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.561	+/-0.010	0.562				
0.30	+/-0.030	0.30				
0.88	+/-0.030	0.88				
0.13	+/-0.030	0.13				
0.31	+/-0.030	0.31				
24.995	+/-0.010	24.995				
47.958	+/-0.010	47.958				
54.178	+/-0.010	54.178				
2.43	+/-0.030	2.43				
7.77	+/-0.030	7.77				
7.203	+/-0.010	7.203				
3.63	+/-0.030	3.63				
4.00	+/-0.030	4.00				
7.071	+/-0.010	7.071				
7.800	+/-0.010	7.800				
0.050	+/-0.010	0.050				

Measured by:	Audited by:	Preliminary Approval:
Date:	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	11.10.13	New Issue P/O D4406-043	KJ	
B	12.03.08	Dimensions revised per Dwg Rev B	KJ	

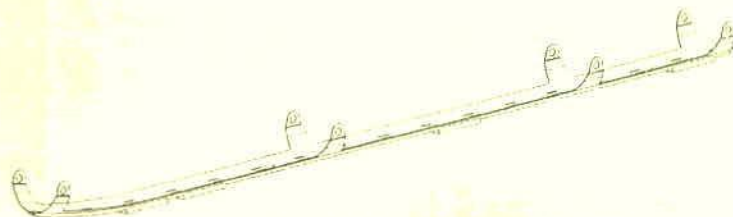
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

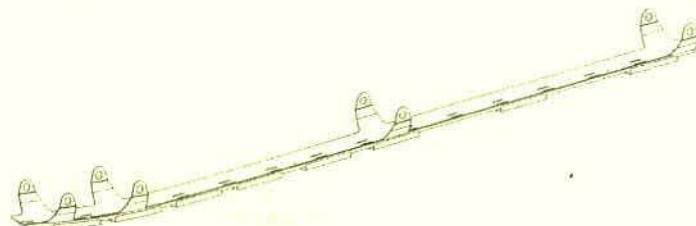
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4406-041 FWD WEARPLATE ASSY



D4406-043 AFT WEARPLATE ASSY

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D4406-041	FWD WEARPLATE ASSY
2		X	D4406-043	AFT WEARPLATE ASSY
3	1		D4406-1	PLATE
4	1		D4406-3	PLATE
5	2		D4407-1	BAR
6	2		D4407-3	BAR
7	A/R	A/R	2059B	HARDCOAT
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 10, SHT 2 & 3)

SUPER COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT

WITHOUT NOTICE
 WORK ORDER

82886 MCT
 12/04/10

RELEASE
 2012-02-23
 MCT

REVISE BILL OF MATERIAL, ADD NOTE 13/14 & REVISE NOTE 9 SHT 2 & 3, MODIFY DETAIL E & F (ZN B3 6, C2 6), ADD DETAIL G (ZN C7 6), REVISE D4406-3F TAB LOCATIONS (ZN B5-5)		RF	12.02.16
A NEW ISSUE		RF	11.08.15
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4406	SHEET 1 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR	RF	WEARPLATE ASSY	NTS
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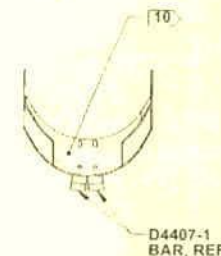
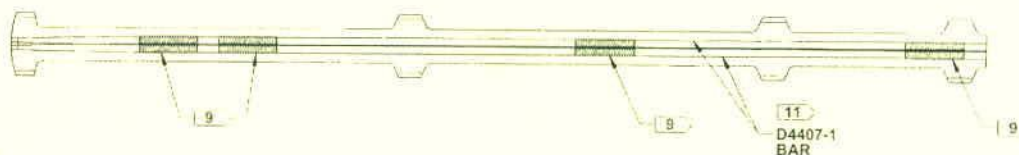
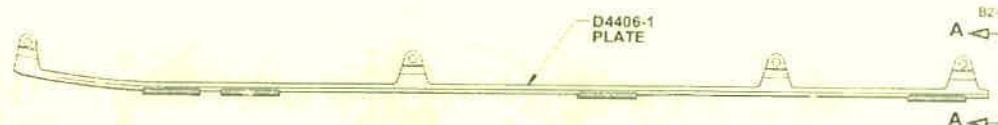
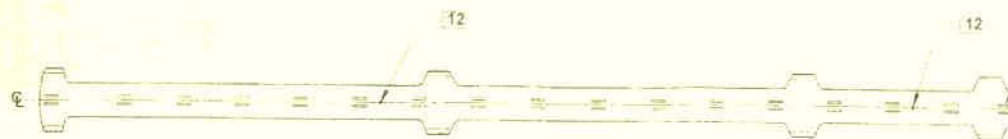
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4406-041 FWD WEARPLATE ASSY

SECTION A-A C3-2
SCALE 2X

RELEASED
2012-02-23
MD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.40 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4407-1 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING
- 12) TRANSFER \varnothing 0.188 HOLES FROM D4406-1 TO D4407-1
- 13) NOTCH D4407-1 BARS AS REQUIRED TO FORM TO D4406-1 PLATE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4406	SHEET 2 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR	RF	WEARPLATE ASSY	NTS
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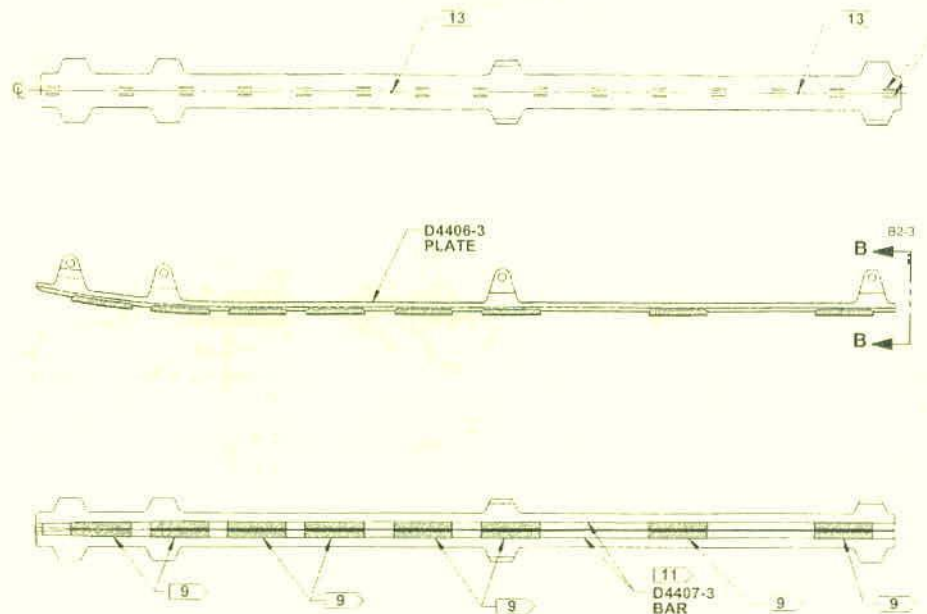
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

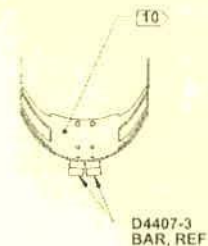
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



82886



D4406-043 AFT WEARPLATE ASSY

SECTION B-B C3-3
SCALE 2X

RELEASE
2012-02-23

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.73 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4407-3 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING
- 12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY
- 13) TRANSFER $\phi 0.188$ HOLES FROM D4406-3 TO D4407-3
- 14) NOTCH D4407-3 BARS AS REQUIRED TO FORM TO D4406-3 PLATE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO D4406	REV. B
MFG APPR	RF		SHEET 3 OF 6
APPROVED	RF	TITLE WEARPLATE ASSY	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

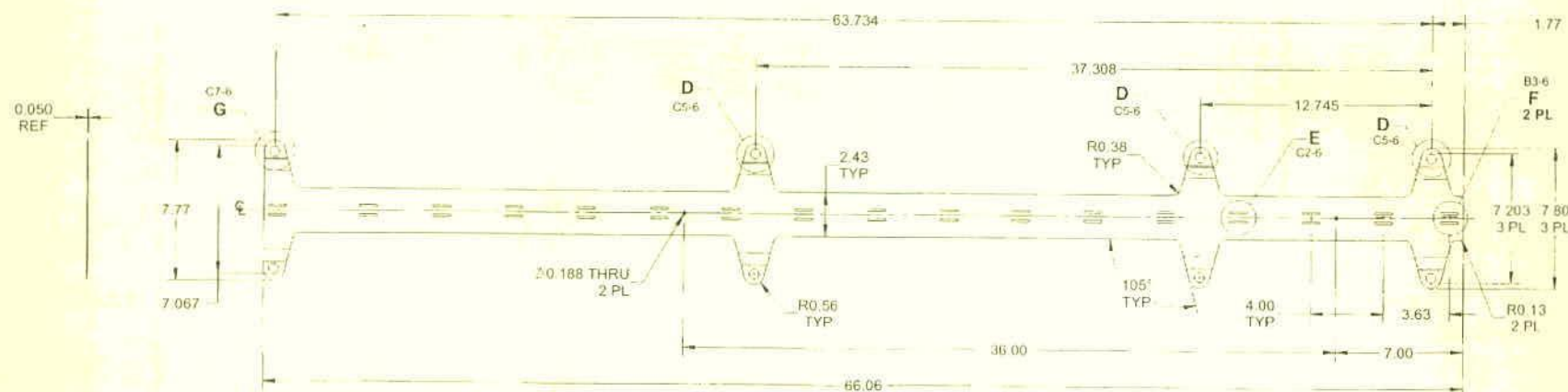
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4406-1 PLATE
(MAKE FROM D4406-1F)



D4406-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.7 lbs

RELEASED
2012-02-22
mf

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DS</i>	DRAWING NO. D4406	REV. B
MFG. APPR.	<i>DS</i>		SHEET 4 OF 6
APPROVED	<i>mf</i>	TITLE	SCALE
DE APPR.	<i>mf</i>	WEARPLATE ASSY	NTS
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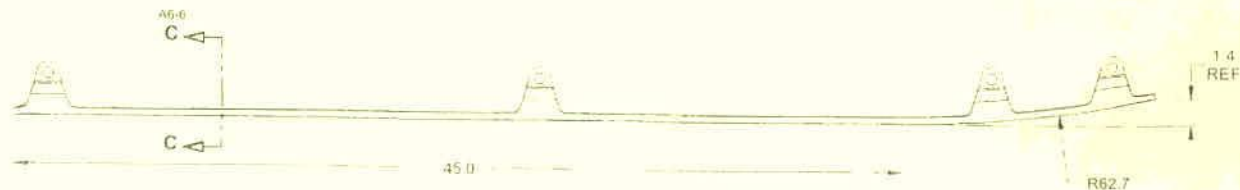
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

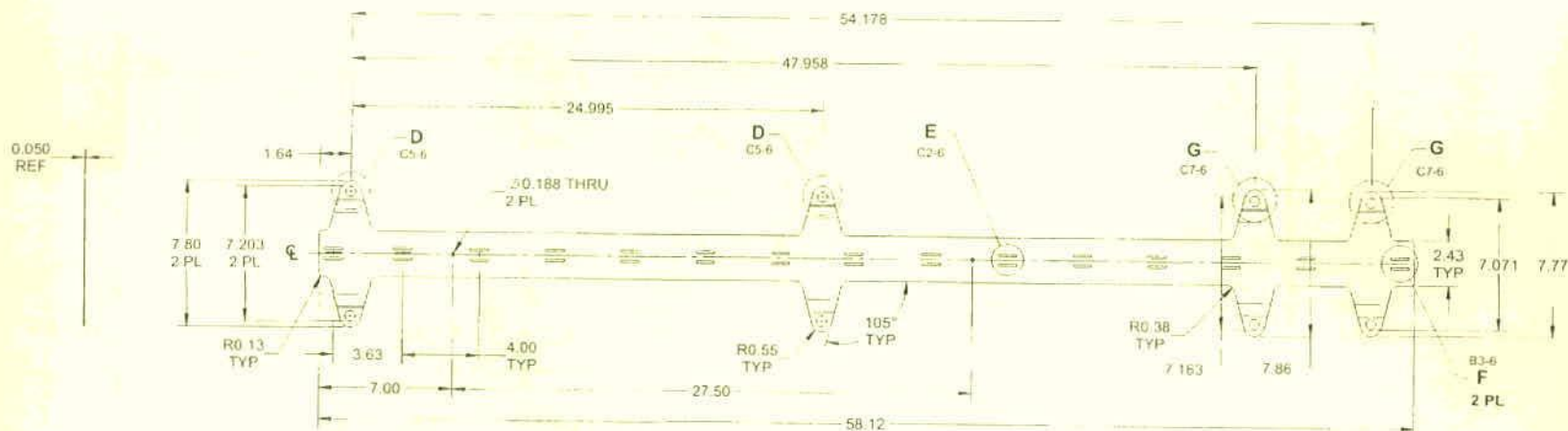
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4406-3 PLATE
(MAKE FROM D4406-3F)

82886



B D4406-3F FLAT PATTERN

RELEASED
2012-02-23
MP

NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.4 lbs.

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO:	REV. B
MFG. APPR.	RF	D4406	SHEET 5 OF 6
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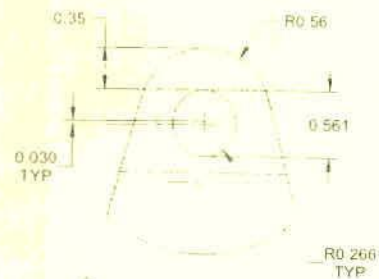
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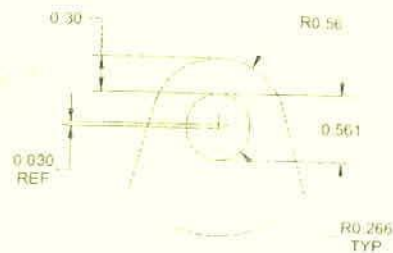
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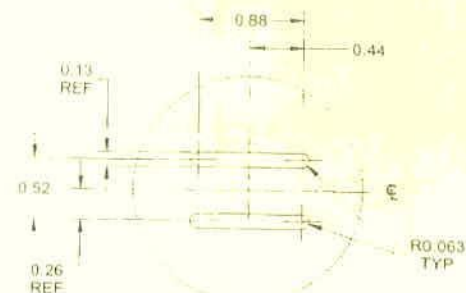
DETAIL G
SLOT DETAIL TYP
SCALE 6X

C2-4
C3-4
C5-5
C6-5



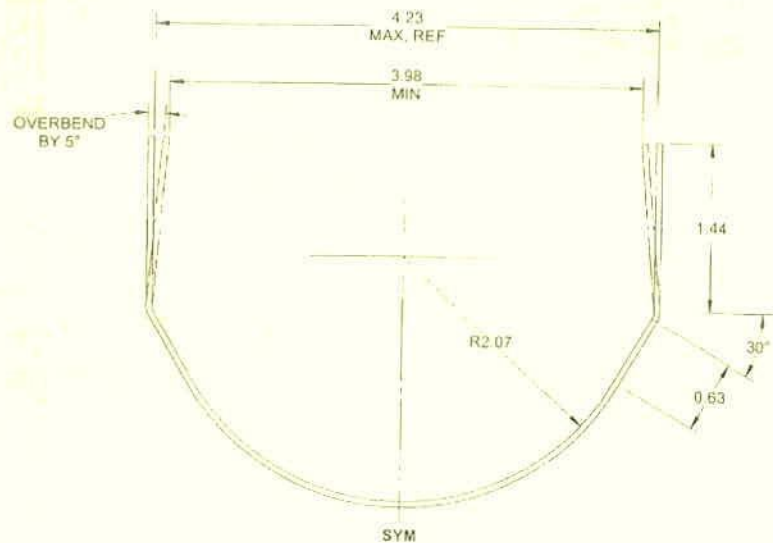
DETAIL D
SLOT DETAIL TYP
SCALE 6X

C2-4
C3-4
C5-5
C6-5



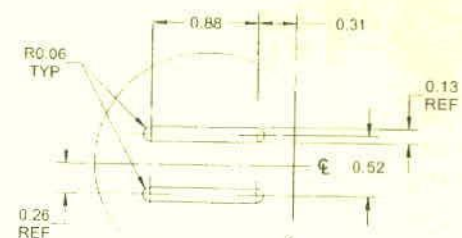
DETAIL E
SLOT DETAIL TYP
SCALE 6X

C2-4
C4-5



DETAIL C
DETAIL TYP
SCALE 6X

D2-4
D6-5



DETAIL F
SLOT DETAIL TYP
SCALE 6X

C1-4
B1-5

RELEASED
2012-02-23
MP

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. B
MFG APPR		D4406	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR		WEARPLATE ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries